

Date: Tuesday, 7/1/2008 2:33:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING		
Job Number	: 40181		Part Number	: D31835		
Estimate Number	: 10091		Drawing Number	: D3183 REV. C1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/1/2008	S.O. No. :	Drawing Revision	: C1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: PURCHASED PARTS			
Previous Run	: 39759		Due Date	: 7/8/2008		Qty: 60 Um: Each
Written By	:					
Checked & Approved By	:					
Comment	:		Est: A 03.03.27	New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 60609

Bearing as per Dwg D3183

Single row, deep groove, Conrad type, shielded

Possible Supplier: NSK P/N 6800ZZ

Certificate of conformity note is required

C:\08\107102

(60)

2.0	6800ZZ	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)

BEARING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 95

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 40181

Part Number: D31835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

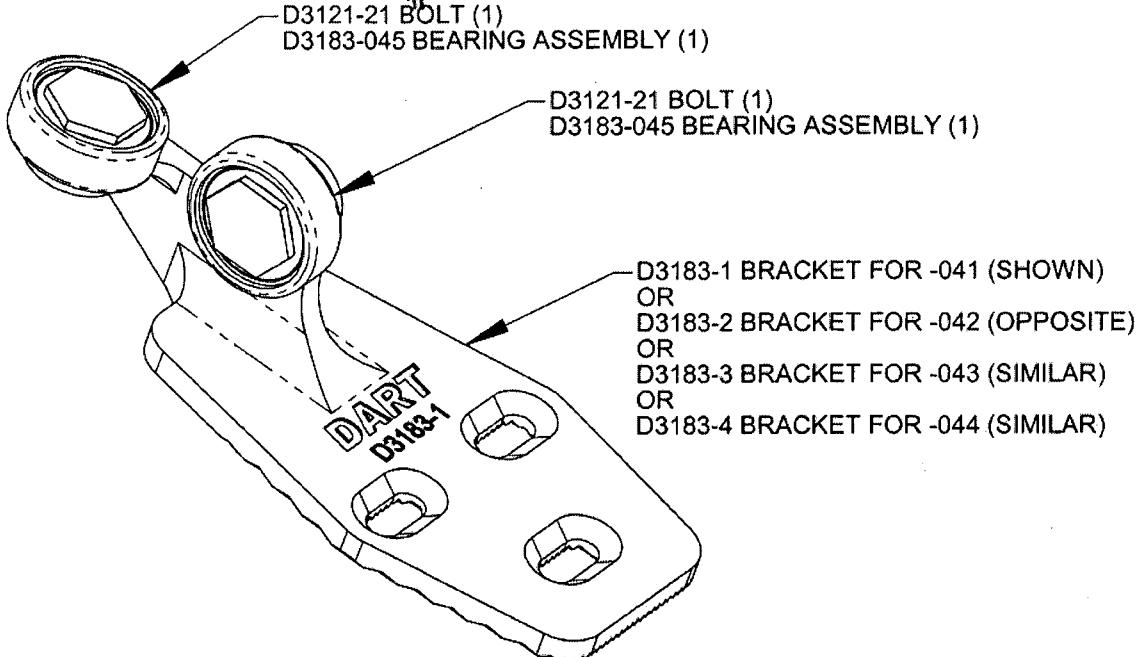
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

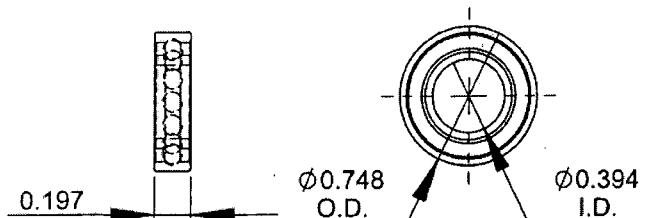
NOTE: Date & initial all entries

DART

DESIGN <i>#</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3183
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED04.03.01 *[Signature]*

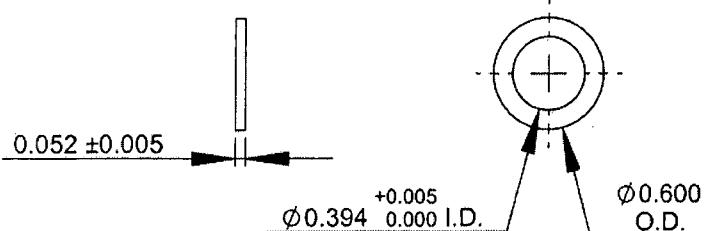
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



**D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
 2) POSSIBLE SUPPLIER: NSK P/N 68007Z
 3) ALL DIMENSIONS ARE IN INCHES

RETURN TO
ENGINEERING
NO. 40181
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40181



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R)
 ANNEALED
 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
 3) TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES

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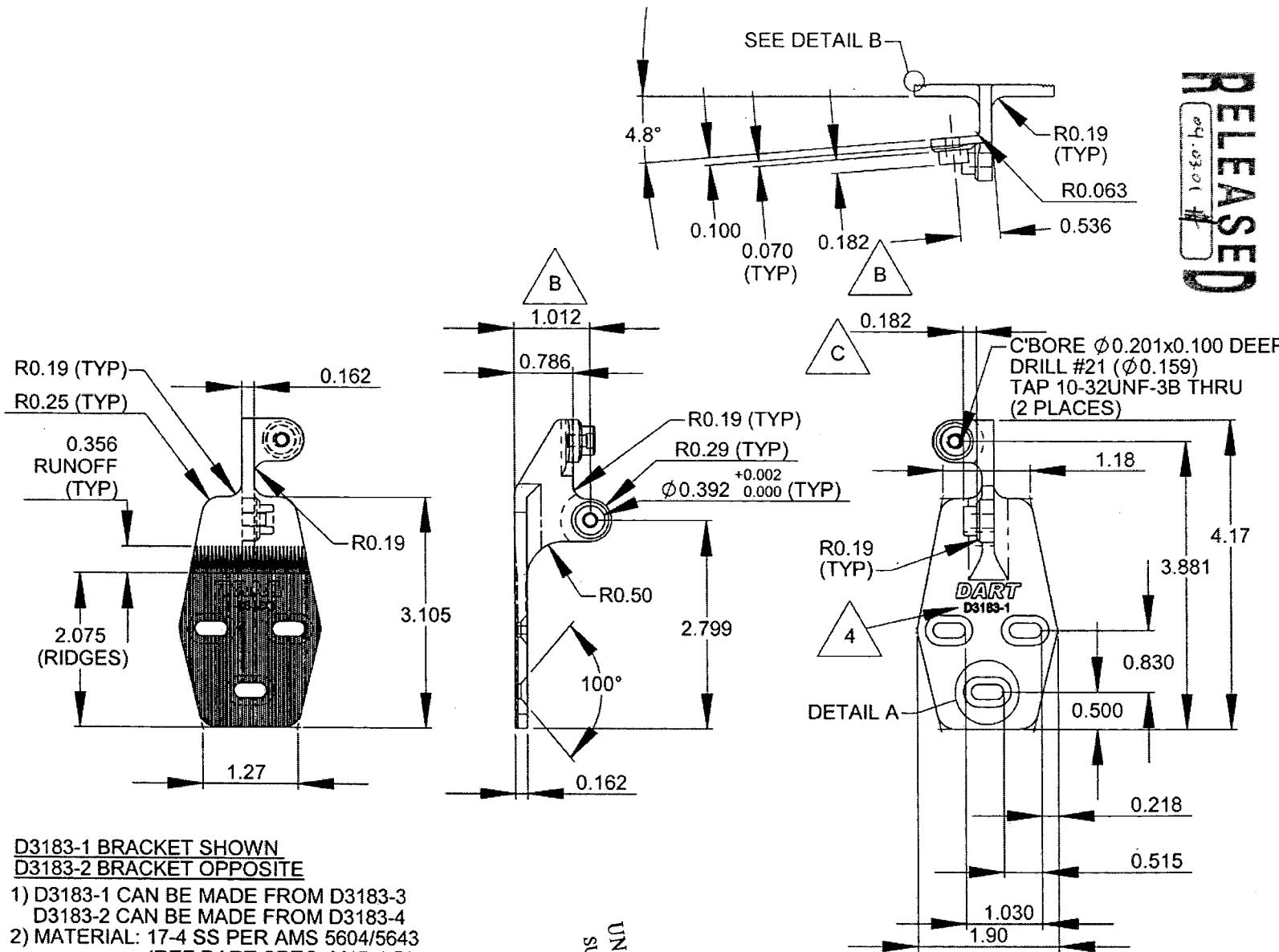
DART

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DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SHEET 2 OF 4
		SCALE
		1:2

RELEASED

04.02.17



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

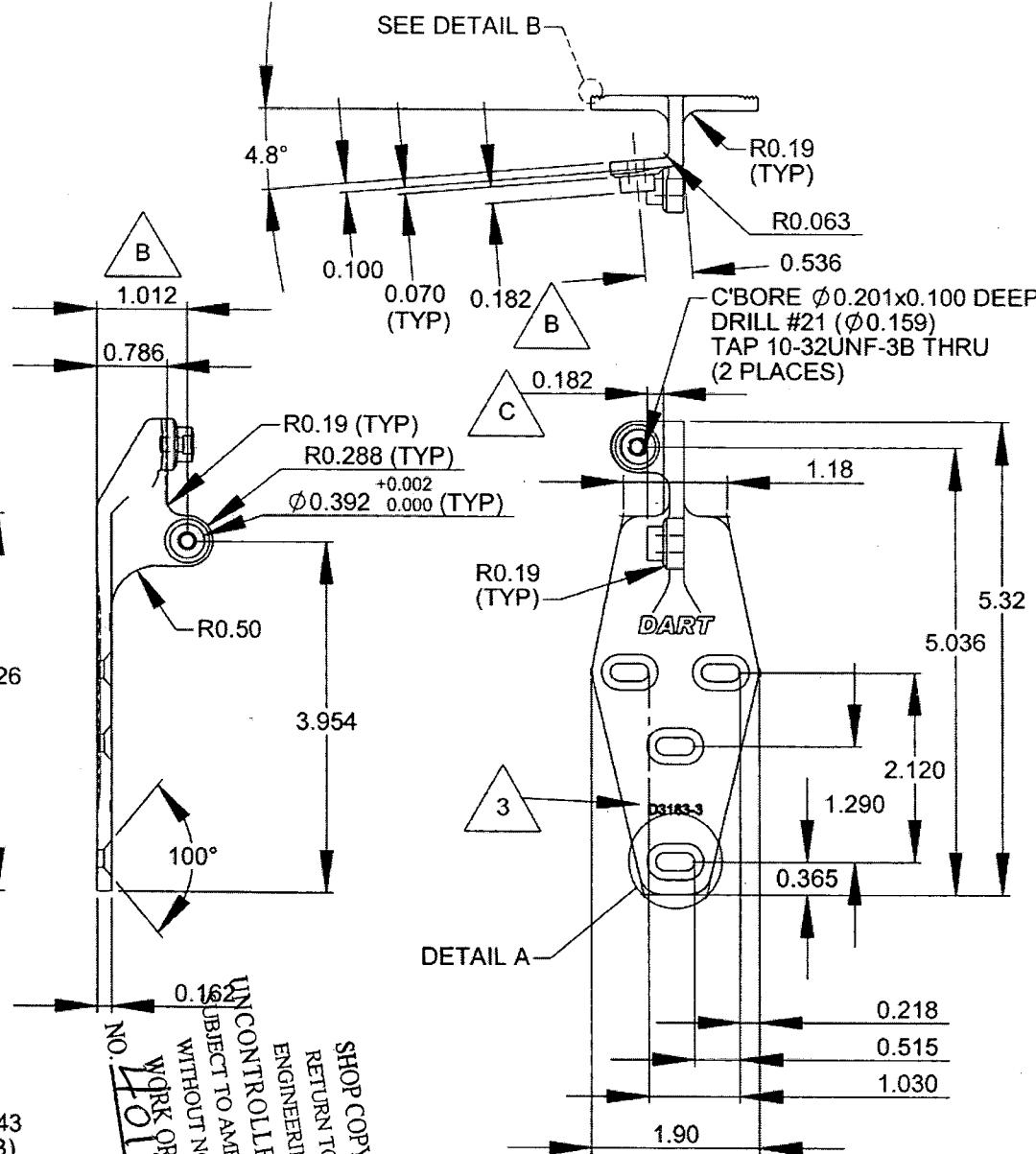
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 40181
WORK ORDER

RELEASER
10-22-84

D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) ENGRAVE DART P/N & LOGO AS SHOWN
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

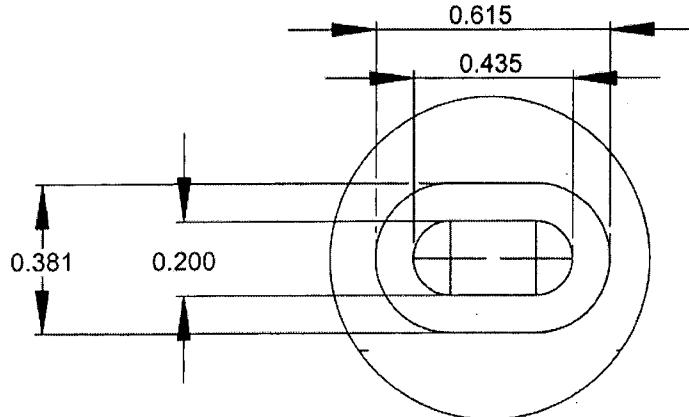
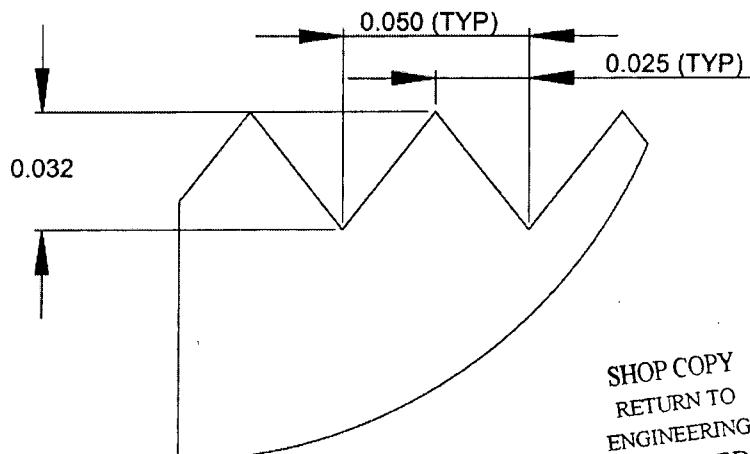


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WORK ORDER
NO. 4018
ksi

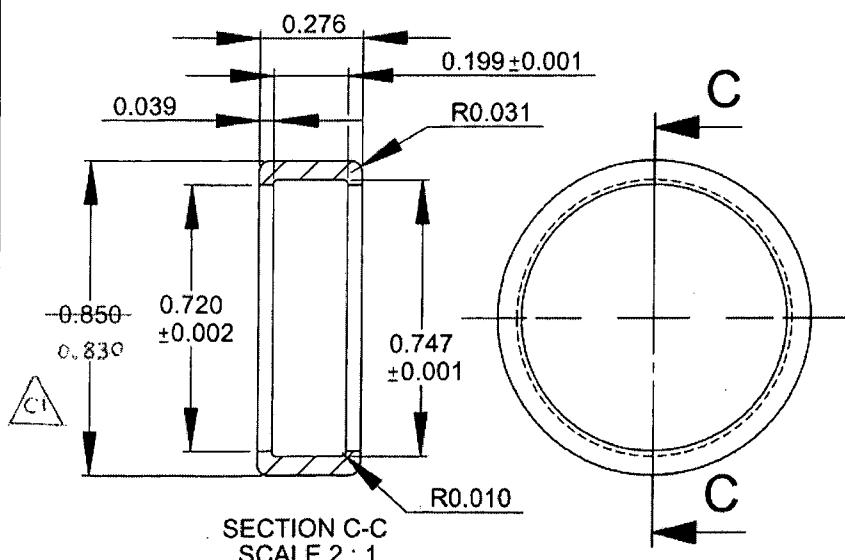
DESIGN		DRAWN BY <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:2	SHEET 3 OF 4

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	04.02.17	D3183	SHEET 4 OF 4 1:1

DETAIL A (2 : 1)**RELEASED**
04.03.01DETAIL B (20 : 1)

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WITHOUT NOTICE
WORK ORDER
NO. 40181

SECTION C-C
SCALE 2 : 1**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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GB GENERAL BEARING SERVICE, INC.

GST # R101979094

SOLD TO: DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY, ON.

K6A-1K7

SALE MADE BY: DR
SHIP VIA:

CUSTOMER ORDER #: 00006669

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	QTY	SHIP TO	PRICE EXTENSION
6000-2Z	BALL BEARING	44	44	489.12
				213.16
				G.S.T. 10.76

PACKING SLIP NO: 630855-0

RECEIVED BY:

1229210

THIS FORM MUST BE COMPUTER PRINTED TO BE VALID & O.E.
DO NOT USE INK OR PENCIL

DON T ÊTRE IMPRIMÉ PAR ORDINATEUR POUR ÊTRE VALIDE E & O.E.

DART**Purchase Order****FAXED**
Scanned

Date Jul 02, 2008	Page 1
Purchase Order Number PO00006669	

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

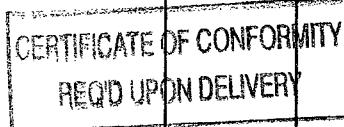
General Bearing Service
386 Main Street
Hawkesbury, ON K6A 1A5
Phone (613) 632-9914
Fax (613) 632-2751

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7

Reference	Contact	Vendor Number VC-GEN001	PO Date Jul 02, 2008	Terms N30	Ship Via	Expected Arrival Jul 04, 2008
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Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
60.0000	6800ZZ	Bearing Comments: AS PER DWG D3183 REV. C1 SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED NSK P/N: 6800ZZ B40181	7/4/2008	No	4.890000	Each	293.40



Comments:	Tax Summary: GST GSTME GSTND	14.67	Less: included tax	0.00
		14.67		
		Subtotal		293.40
		Total tax		14.67
		Total purchase order in CAD Dollars		308.07

Entered By: *CL* CLAVOIEApproved By: *LL*